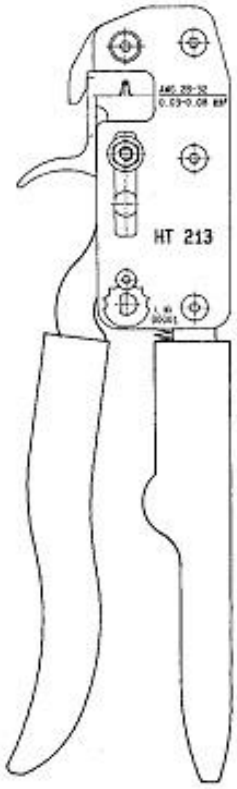
HT213
Handpistol for PV
AWG 28 - 32
User's Guide



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1. DESCRIPTION

The handtool HT 213 is designed to crimp Mini PV terminals In the Wire range AWG 28-32.

2. OPERATING INSTRUCTIONS

1. Place the handtool in your left hand, so that the movable handle (item 14) and connector fixture (item28) can be actuated by your thumb.
2. Actuate connector fixture and place terminal in its correct position, touching the wire stop,and with the U-shape facing the crimper.
3. Use wire which is stripped over a length of 4 ± 0.25 mm.
4. Place the wire into the barrel of the terminal,so that the end of the wire touches the wire stop.
5. Close the handtool by moving the handle (item 4),while the wire is held in position.
6. When the handtool is completely closed, the movable handle (item 14),may be returned to its starting position.
7. Finally take the crimped terminal from the handtool.

Note: The handtool has stops, which prevents opening the tool before the crimp action is completed.
Should it be necessary, the stop can be released by turning the stop ring (item 3) at the back side of the tool in the direction indicated by the two yellow arrows.
Keep the movable handle under light pressure during this operation.

3. SPECIFICATIONS

3.1 Product information:

- Mini PV
- Wire range AWG 28-32, (0.03 - 0.08 mm^2
- Crimp height 0.66 - 0.71 mm
  .0260 - .0280 inches

Adjusted crimp height by manufacturer: ……. Mm

4. ADJUSTMENTS

4.1 Adjustment of bell-mouth

1. Take an open-ended spanner or a ring spanner number 8 (8 mm).
2. Place the spanner around the nut (item 36),on the site opposite the connector fixture (item 28).
3. To increase the bell-mouth at the box side of the terminal,the nut (item 36) should be turned to the left.

NOTE: After adjusting, give with a hammer a slight touch on the stud (item 26),to ensure that nut and washer (item 35) are positioned against the cover plate (item 1).

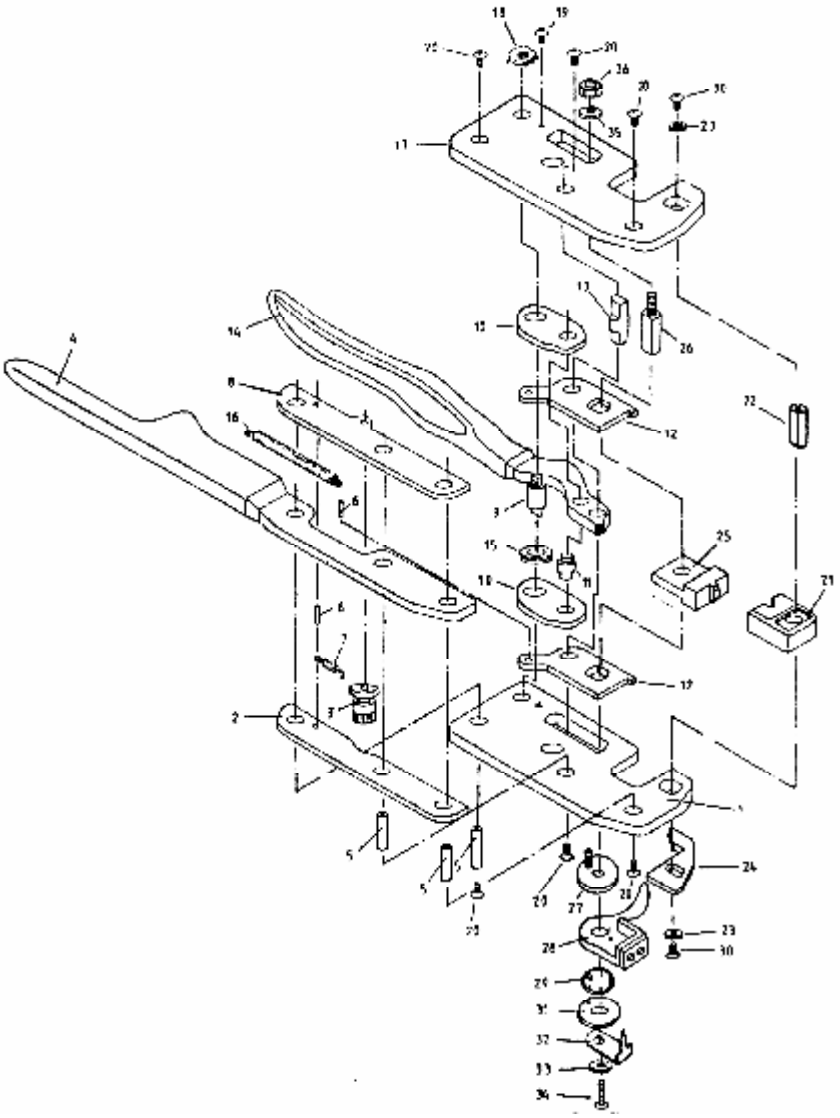
4. To decrease the Bell-mouth at the box side of the terminal,the nut (item 36) should be turned to the right.

4.2 Adjustments of crimp height:

Eventually the crimp height must be readjusted,due to wear of the tool hinges.(For specified crimp heights see below.)
Readjusting is done by loosening screw (item 19) and turning the stop ring (item 9) one step, to change the crimp height approximately 0,05 mm

5. MAINTENANCE

- Regular checks must be made for possible gold or tin build-up on the crimper and the anvil.
- If necessary,these parts may be carefully cleaned.
- Damaged parts must be replaced immediately.For part numbers,see EPL list.
- Because of the coating used on the movable parts of this handtool, oiling of parts is not necessary.



6. PARTS

Epl list

item no	part No	description	qty per assy
1	172384a	Cover plate, lower	1
2	172383	Lower spacer plate	1
3	172391	Pawl	1
4	172380a	Handle, permanent	1
5	172397	Connecting pin	3
6	172393	Pin dia 2x7,8	2
7	172392	Extension spring No 19	1
8	172382	Upper spacer plate	1
9	172389	Eccentric pin	1
10	172387a	Connecting plate	2
11	172388	Hinge pin	1
12	172386	Holding plate	2
13	172395	Guide pin	1
14	173583a	Handle, mobile	1
15	190583	Stop roll	1
16	172394a	Extension spring No 35	1
17		Cover plate,upper	1
18	190582	Stopring	1
19	5305-003-050	But. hd. cap screw M3 x 4	1
20		But. hd. cap screw M4 x 7	6
21	177596	Crimper & Anvil set	1
22	172399	Thread bush,crimper	1
23	173584	Washer B 4,3 Din 125-ST	2
24	190772	Connector fixture block	1
25	see item nr	Is now sold as a set: art. Nr.	1
26	21	177596	1
27	173576	Stud	1
28	173577	Bush	1
29		Connector fixture	1
30	173579	Torsion spring No.30	2
31	5305-003-051	But. hd. cap screw M4 x 6	1
32	173580	Disc	1
33	173581	Wire stop	1
34	190585	Spacer	1
35	5305-003-009	But. hd. cap screw M4 x 16	1
36	5310-007-005	Washer B 5,3 Din 125-ST	1
	5310-002-003	Hex nut M5 Din 934	

7. CONTACT

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